

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009685**Date Inspected:** 07-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1745**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhan Bo, Yu Dong Ping.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, East Tower, Lift 4, D/E Corner Seam(Inside).

SMAW welding of weld joint ESTL4-2B/L-61A; located on Bay11, East Tower, Lift 4. Welders are identified as 040775, 053316; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-C-U2-F.

Bay11, West Tower, Strut Plate.

SAW welding of weld joint WD1-STSA3-2-99M-2-8B; located on Bay11, West Tower. Welders are identified as 047304; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4221-B-U3C-S-1.

Bay11, South Tower, Struts.

FCAW Repair welding of weld joint SD1-A6002-18-11A/B (WRR # T-WR2279); located on Bay11, South Tower. Welders are identified as 049099; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-3.2G(2F)-REPAIR.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This QA Inspector carried out NDE on following

Bay 10, South Tower, Lift 4, 1100mm Length of Seam(ONLY OUT SIDE).

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) & Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT & UT report (TL-6028 & TL-6027) for this date. The members are identified as WSTL3-4B/K-81A/B.

Bay 10, North Tower, Strut Web Plate.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as ND1-A6002-8-5A/B, 6A/B.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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